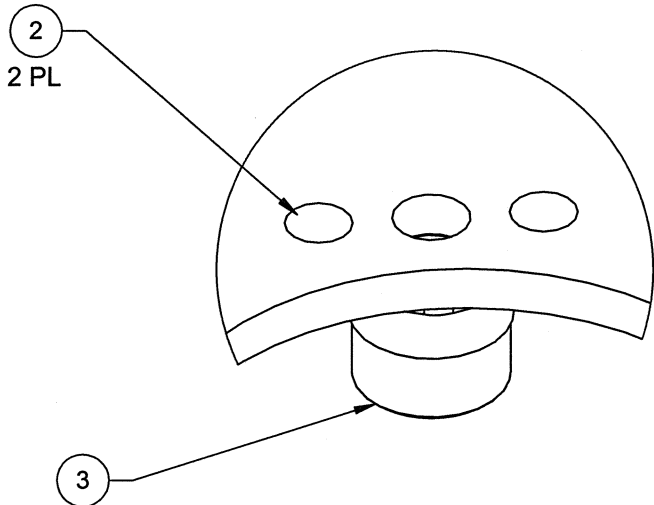
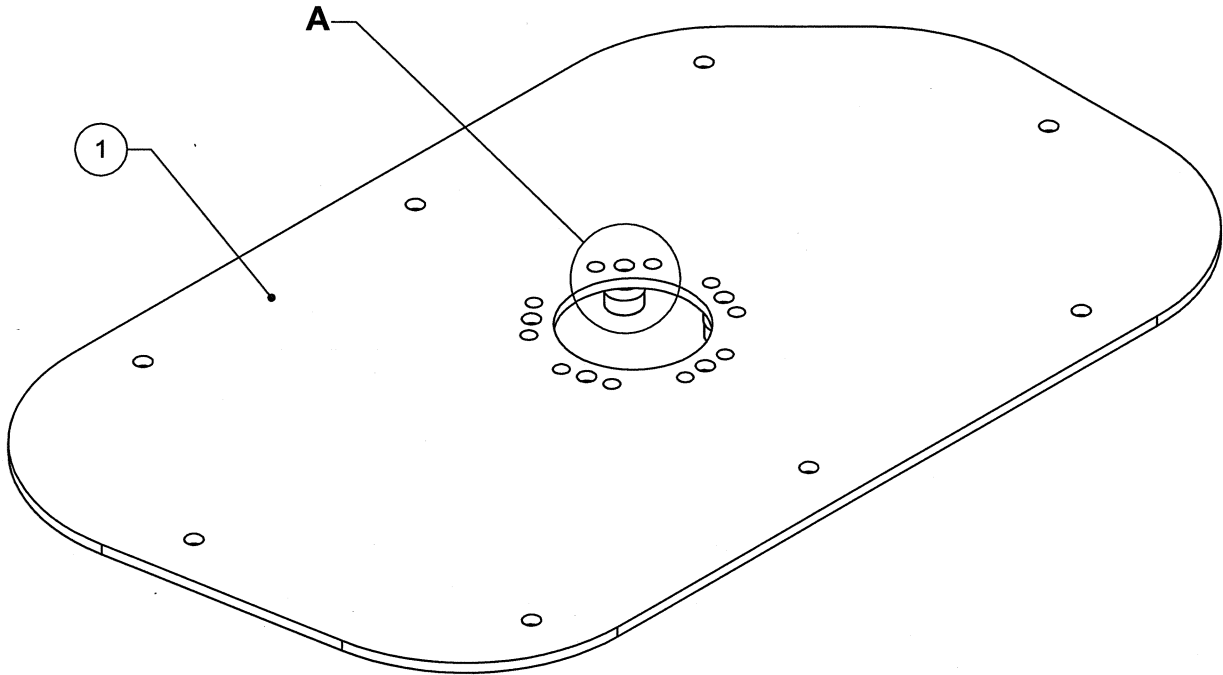


ITEM	QTY -041	P/N	DESCRIPTION
	X	D4577-041	FWD ACCESS PANEL ASSEMBLY
1	1	D4577-5	FWD ACCESS PANEL
2	10	MS20426AD3-5	RIVET, SOLID, CSK
3	5	NAS1474R3	ANCHOR NUT (OR NAS1474A3 OR NAS1474S3 OR NAS1474F3)



DETAIL A  
SCALE 4X  
5 PL

D4577-041 FWD ACCESS PANEL ASSEMBLY

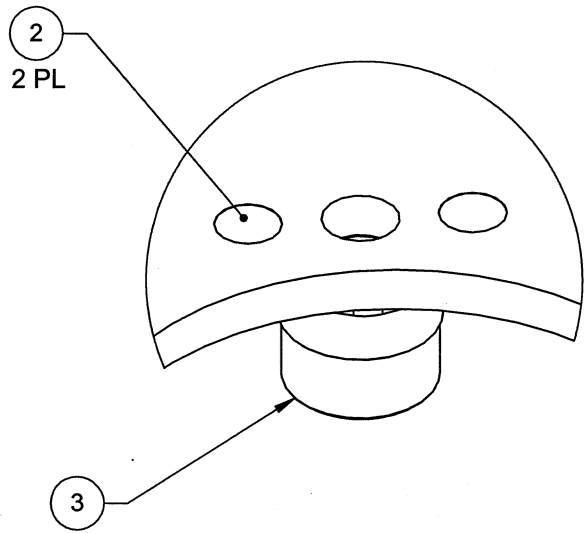
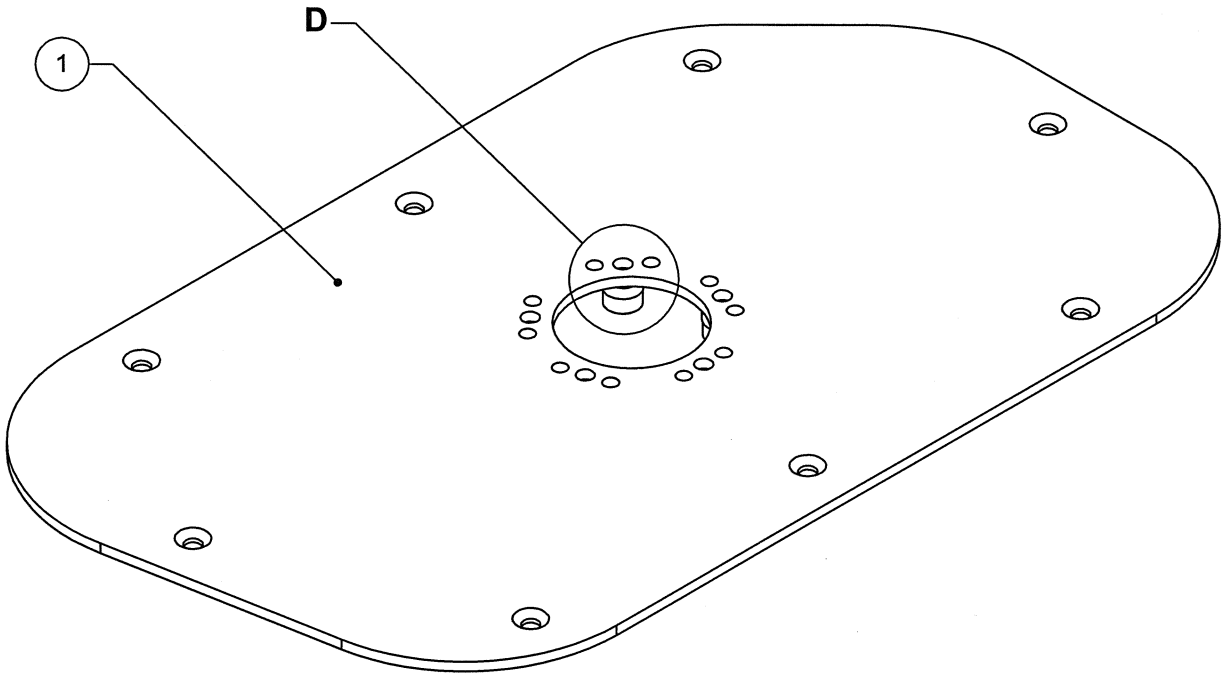
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.08 lbs

RELEASED  
2019 OCT 07  
ECN 19-032

APPROVED

D	ADDED D4577-7/-9/-11/-043 ACCESS PANELS, ADDED NOTE 8 (ZN A8-3,4,5). REF PAR15-432, D5473-5 WAS D4025-5 (ZN C1-5)	PM	19.02.05
C	REMOVED POWDER COAT FINISH ON ALL PARTS (SHT 1-3); FORMAT UPDATED; REVISED WEIGHT (SHT 1); VARIOUS MINOR DIMENSIONAL CHANGES, ALL PARTS NOW FULLY DIMENSIONED; REMOVED UNNECESSARY VIEWS	AP	14.12.05
B	REMOVE D4001-1; ADD NAS1474R3, ZN C2-1. MODIFY -5 FOR HARDWARE, ZN C5-4. INCREASE THICKNESS OF -1/-3/-5; IS 0.125", WAS 0.063". MODIFY DIMS OF -1/-3/-5.	DC	12.03.30
A	NEW ISSUE	DC	12.01.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	SAD	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4577	SHEET 1 OF 8
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	ACCESS PANEL	NTS
DATE	19.02.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4577-043	FWD ACCESS PANEL ASSEMBLY
1	1	D4577-11	FWD ACCESS PANEL
2	10	MS20426AD3-5	RIVET, SOLID, CSK
3	5	NAS1474R3	ANCHOR NUT (OR NAS1474A3 OR NAS1474S3 OR NAS1474F3)



**D** **D4577-043 FWD ACCESS PANEL ASSEMBLY**

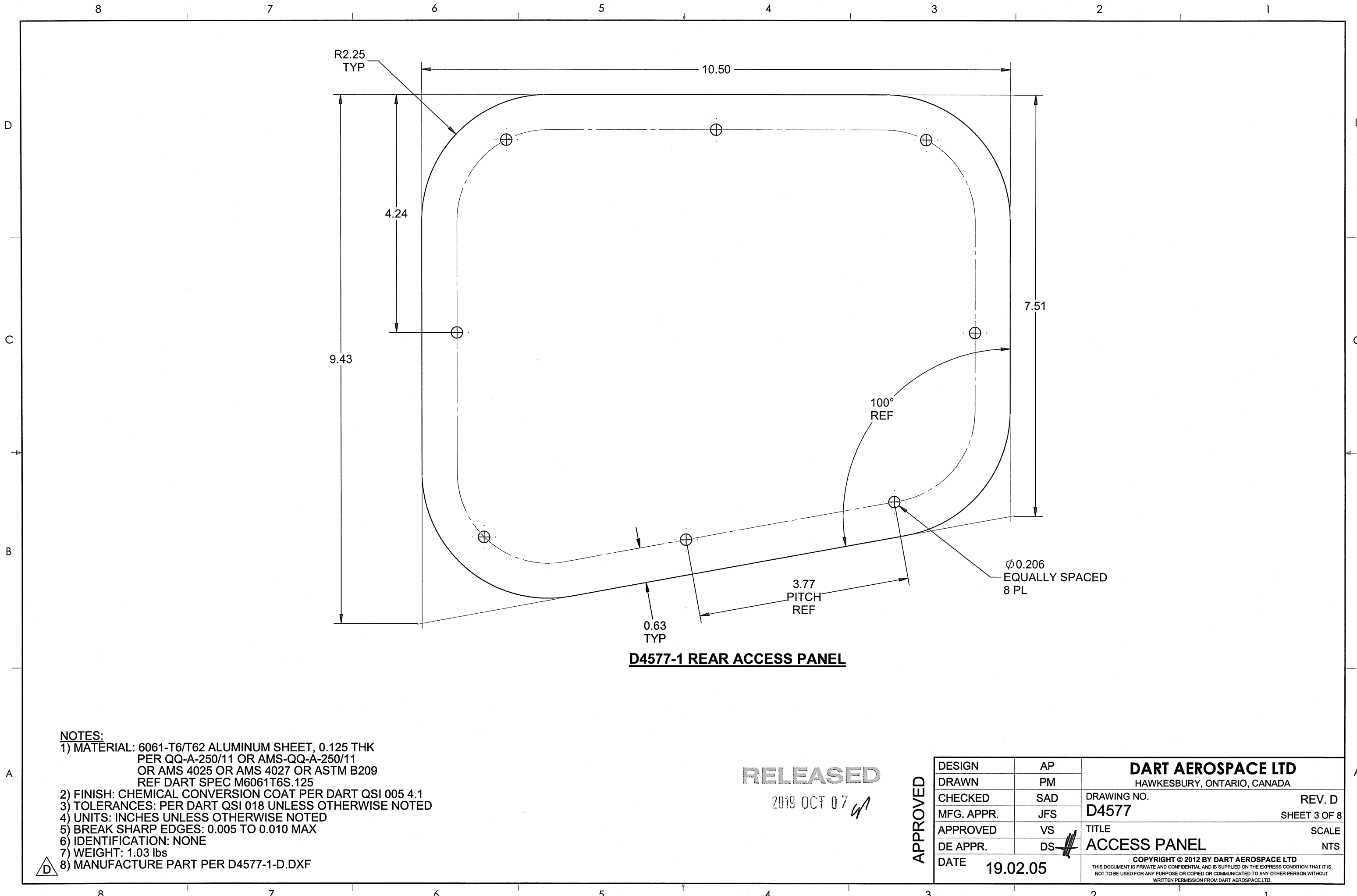
**DETAIL D**  
SCALE 4X  
5 PL

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.08 lbs

RELEASED  
2019 OCT 07

APPROVED

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	SAD	DRAWING NO.	REV. D
MFG. APPR.	JFS	<b>D4577</b>	SHEET 2 OF 8
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	<b>ACCESS PANEL</b>	NTS
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**D4577-1 REAR ACCESS PANEL**

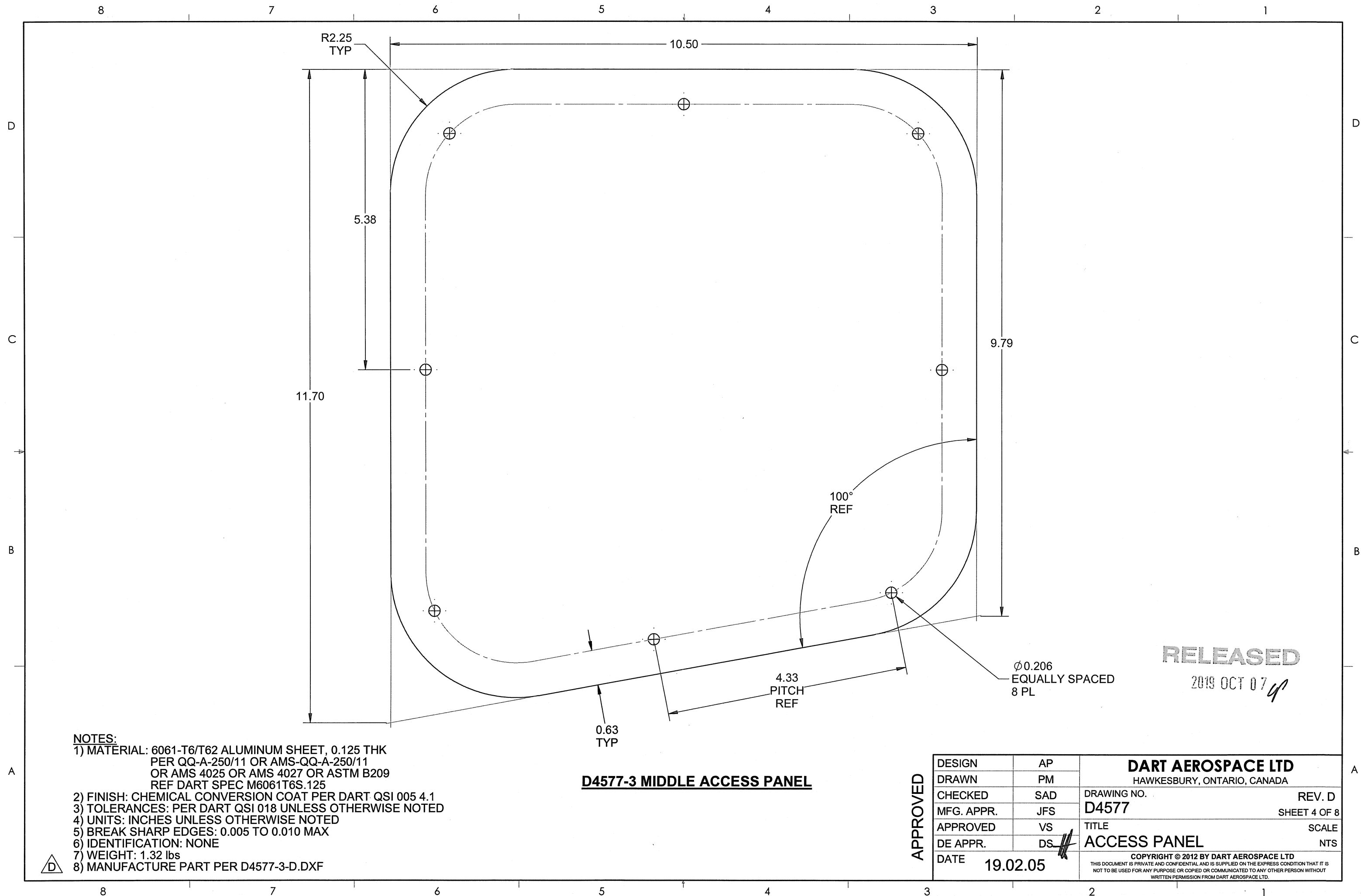
- NOTES:**  
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 1.03 lbs  
8) MANUFACTURE PART PER D4577-1-D.DXF

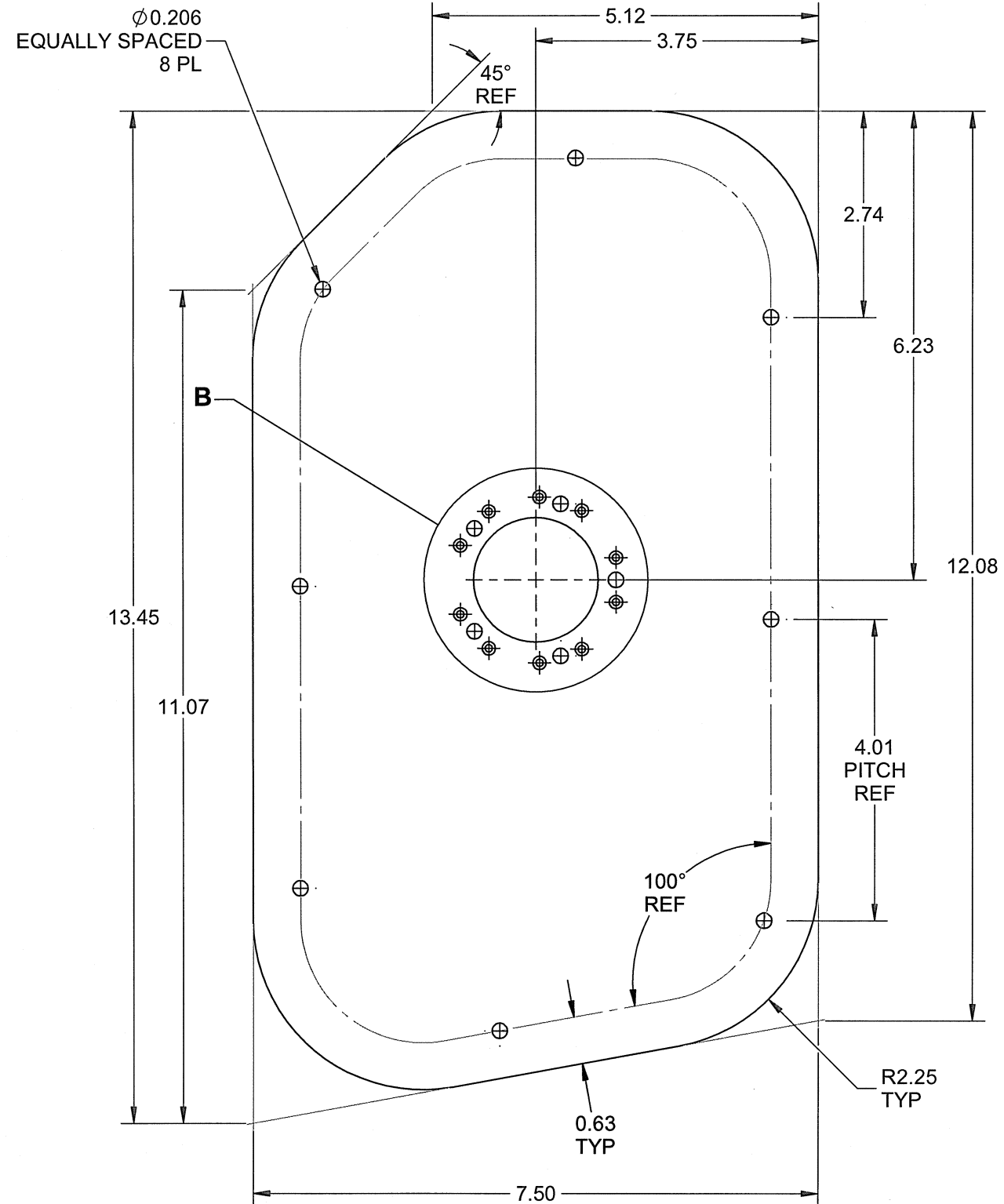
RELEASED

2019 OCT 07

APPROVED

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	SAD	DRAWING NO.	REV. D
MFG. APPR.	JFS	<b>D4577</b>	SHEET 3 OF 8
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	<b>ACCESS PANEL</b>	NTS
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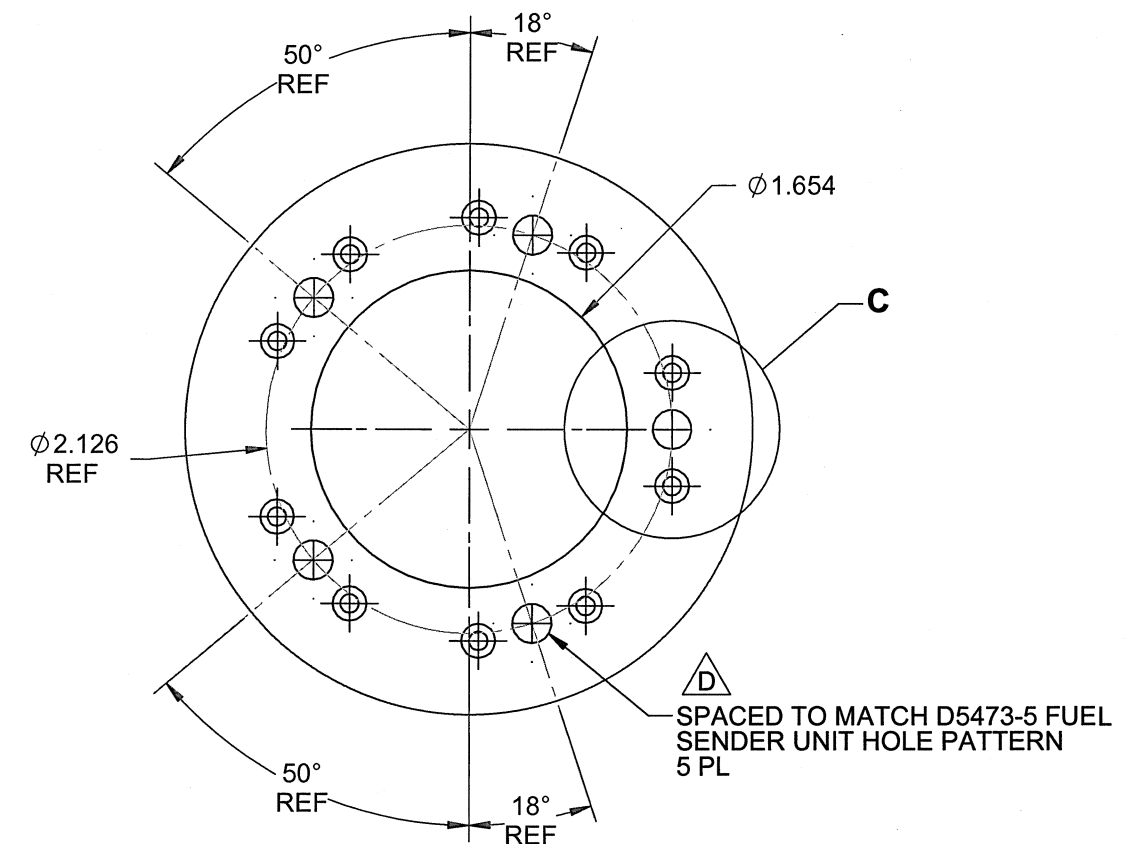




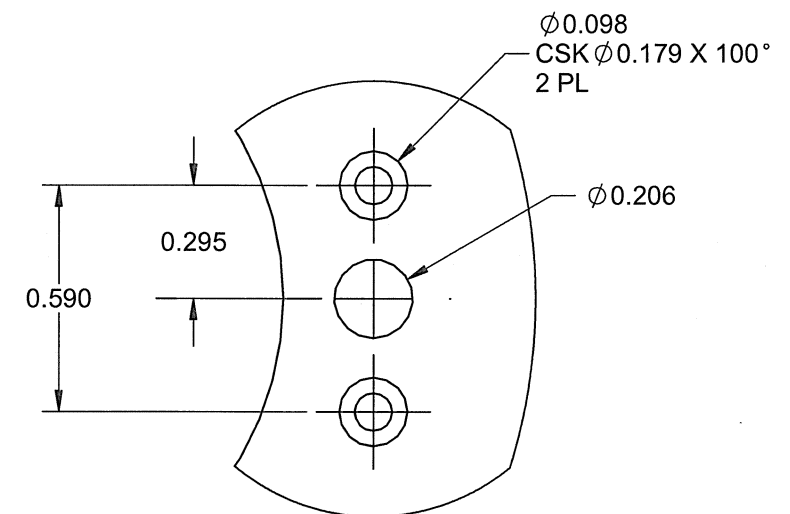
**D4577-5 FWD ACCESS PANEL**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.06 lbs
- 8) MANUFACTURE PART PER D4577-5-D.DXF



**DETAIL B**  
SCALE 2X



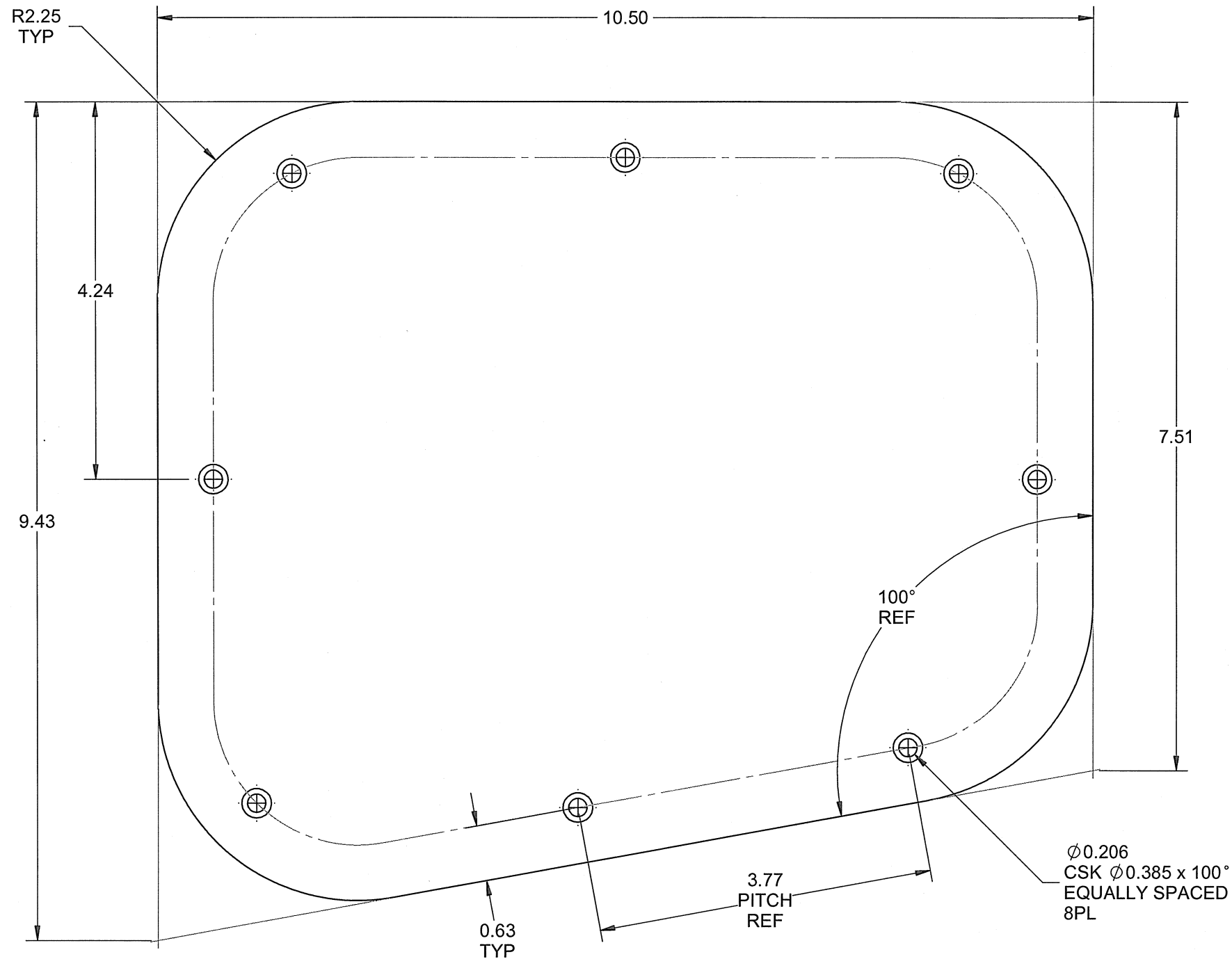
**DETAIL C**  
SCALE 2X  
5 PL

**RELEASED**

2019 OCT 07

APPROVED

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	SAD	DRAWING NO.	REV. D
MFG. APPR.	JFS	<b>D4577</b>	SHEET 5 OF 8
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	<b>ACCESS PANEL</b>	NTS
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**D4577-7 REAR ACCESS PANEL**

**NOTES:**

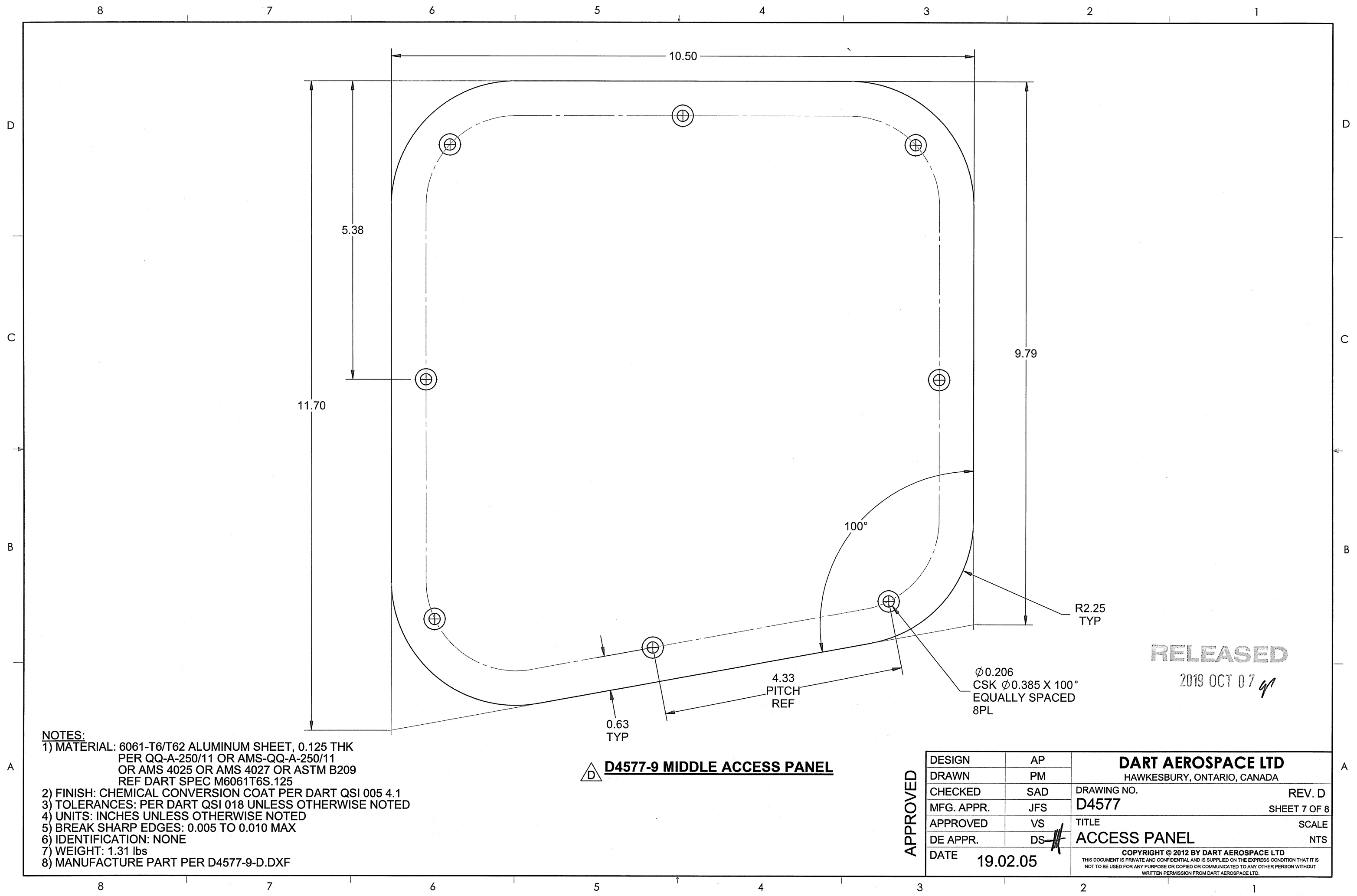
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.02 lbs
- 8) MANUFACTURE PART PER D4577-7-D.DXF

**RELEASED**

2019 OCT 07

**APPROVED**

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	SAD	DRAWING NO. <b>D4577</b>	REV. D
MFG. APPR.	JFS		SHEET 6 OF 8
APPROVED	VS	TITLE <b>ACCESS PANEL</b>	SCALE
DE APPR.	DS		NTS
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- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.31 lbs
  - 8) MANUFACTURE PART PER D4577-9-D.DXF

**D4577-9 MIDDLE ACCESS PANEL**

APPROVED

DESIGN	AP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PM		
CHECKED	SAD	DRAWING NO.	REV. D
MFG. APPR.	JFS	<b>D4577</b>	SHEET 7 OF 8
APPROVED	VS	TITLE	SCALE
DE APPR.	DS	<b>ACCESS PANEL</b>	NTS
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